

Work Order ID 67305

Tuesday, March 15, 2011 9:16:35 AM



Page 1

Item ID: D205-634-011DG

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube, Drab Green

Start Date: 3/15/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 3/15/2011 Req'd Qty: 1.00

Customer:

Reference: *lework*

Approvals: Process Plan: *[Signature]*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D205-634-011DG

CHG 008

8460317

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D205-634-011DG		CHG	CHG008	
DESC.	Skidtube		STC	SH96-88	
LOT	B67104		STC	SR00563NY	
MODEL	Bell 205/210/212/214/412/UH-1H		STC		
PATENTS: US #5735484 / CA #2222184 EUROPEAN No. # 0828655				MADE IN CANADA D2729-2	

105

0.00



HandFinish

Hand Finishing

Memo

0.00

PULL FROM STOCK
1 X D205-634-011DG B67104

REMOVE CAR, PUT ASIDE TO RE-ASSEMBLE TO SAME TUBE

OK
9/10/11
**POSITIVE
RECALL**

11-3-22

11-03-15 (1)

106

0.00



Skidtubes

Skidtubes

Memo

0.00

REMOVE CRACKED SPACER D4202-1

REPLACE WITH NEW D4202-1 B62308 (49W)

(3RD From Alt)

DP

11-3-15

Work Order ID 67305

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Page 2

Item ID: D205-634-011DG

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube, Drab Green

Start Date: 3/15/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

107

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

no crack found

8/10/11



108

0.00



Powdercoat

Memo

0.00

Powder Coating

TOUCH UP A/R

RE-ASSEMBLE CAP

1 d all 11/03/16

109

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

REPACKAGE PER PPP
USING NEW B/N

8/10/12



Picklist Print

Tuesday, March 15, 2011 9:16:32 AM

Page 1

Work Order ID: 67305



Parent Item: D205-634-011DG



Parent Item Name: Skidtube, Drab Green

Start Date: 3/15/2011

Required Date: 3/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.02.17 new issue DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4202-1		Manufactured	No				Each	325.0000		1			
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Spacer

Location

Loc Qty

Loc Code

LG002

325

65529

13

66121

1

66929

110

67129

201

67308

①

DP 11-3-15

W/O: .		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.03.16	CP 11.03.16 BS/07L	RE-WORK CRACKED 0.058" WALL XBOLT SPACERS. REPLACE WITH 0.049" WALL XBOLT SPACERS THAT ARE OTHERWISE MADE TO D4202 REV.A				CP 11.03.16 BS/07L	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Chris Provencal

From: David Shepherd <dshepherd@dartaero.com>
Sent: March 16, 2011 6:21 PM
To: 'Chris Provencal'
Cc: 'Mike Petsche'; 'Linda Lacelle'; 'Bill Beckett'
Subject: RE: 0.049 Wall Xbolt Spacers

Chris,

The substitution is acceptable. However, I would still like to see that this is repeatable. Per my earlier suggestion, I assume production is building a couple of tubes with 0.049 wall crossbolt spacers to verify that there is no cracking after several swagings???

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Wednesday, March 16, 2011 9:14 AM
To: David Shepherd
Cc: Mike Petsche
Subject: 0.049 Wall Xbolt Spacers

David,

To approve the re-worked xbolt spacers, I'd need to attach an email from you giving OK to substitute the 0.058" wall crossbolt spacers with 0.049" wall crossbolt spacers. The crossbolt spacers are otherwise made to D4202 Rev. A.

The justification would be the initial testing, as recorded in the original design review, which showed that 0.049" wall xbolt spacers were stronger than welded/c-bored crossbolt spacers. These findings were confirmed when we tested another batch of swaged vs welded samples yesterday (March 15th, 2011).

Chris